

Date: Wednesday, 03/09/2008 10:26:18 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206/OH-68 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
Job Number :	41728	Part Number :	D29392UP
Estimate Number :	12933	Drawing Number :	D2939 REV C
P.O. Number :		Project Number :	N/A
This Issue :	03/09/2008 S.O. No. :	Drawing Revision :	C
Prsht Rev. :	NC	Material :	
First Issue :	// Type :	Due Date :	26/09/2008
Previous Run :	34734	Qty:	2 Um: Each
Written By :			
Checked & Approved By :	JULIO 08.9.03		
Comment :	Est Rev:A New Issue 07-07-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: 34873

SS 08/09/08

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

SS 08/09/08 (2)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SS 08/09/08 (2)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SS 08/09/08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:26:18 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 41728

Part Number: D29392UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 08/09/08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.A.

08/09/11

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-11

(X2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 444

8/9/11

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/11

Job Completion



W 08.09.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 41728	
Description: 206 Saddle, Inboard, Right side				Part Number: D2939-2	
Inspection Dwg: D2939 Rev: C DSK: Rev:				Page 1 of 1	

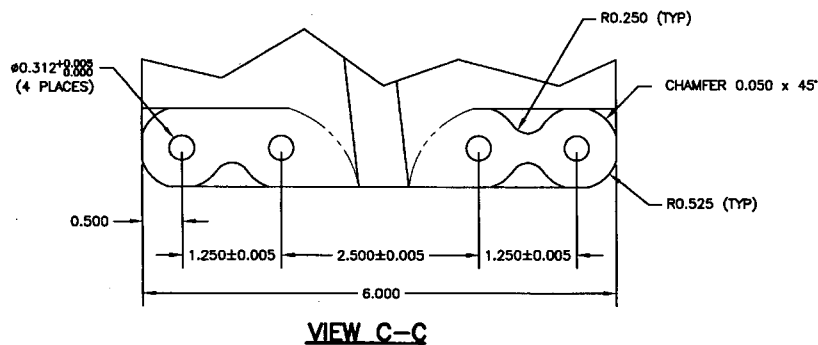
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.125	.125			
B	0.100	0.140		.125	.125			
C	0.100	0.140		.118	.118			
D	0.210	0.230		.220	.220			
E	1.245	1.255		1.250	1.250			
F	1.245	1.255		1.250	1.250			
G	2.495	2.505		2.500	2.500			
H	0.510	0.515		.510	.510			
I	1.572	1.582		1.577	1.577			
J	2.495	2.505		2.500	2.500			
K	0.257	0.262		.258	.258			
L	0.312	0.317		.312	.312			
M	0.235	0.240		.238	.238			
N	0.100	0.140		.120	.120			
O	0.540	0.560		.550	.550			
P	0.490	0.510		.500	.500			
Q	3.715	3.725		3.720	3.720			
R	2.720	2.760		2.750	2.750			
S	0.240	0.270		.250	.250			
T	0.100	0.180		.140	.140			
U	1.625	1.635		1.630	1.630			
V	1.362	1.372		1.370	1.370			
W	0.316	0.321		.320	.320			
X	1.250	1.270		1.260	1.260			
Y	1.565	1.585		1.575	1.575			
Z	0.178	0.198		.188	.188			
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: JS	Date: 08/09/08
Audited by: J.L	Date: 08/09/08
Prototype Approval: N/A	Date: N/A

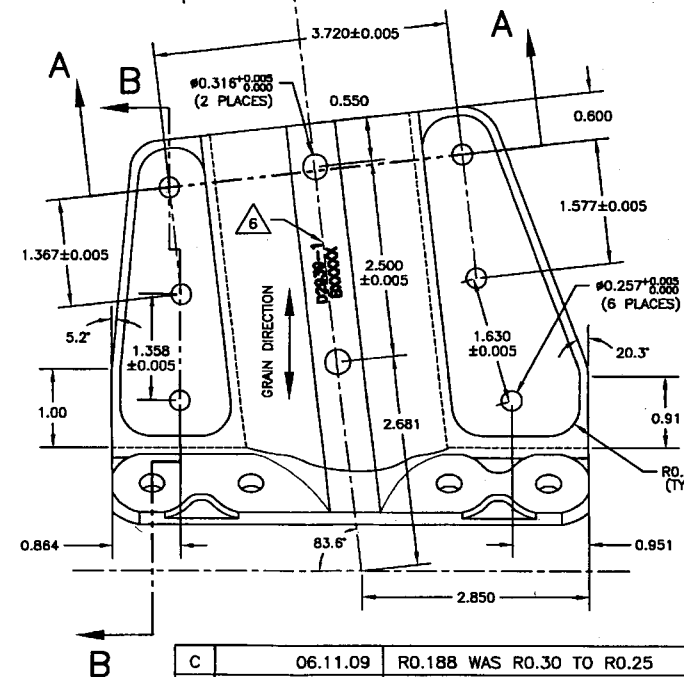
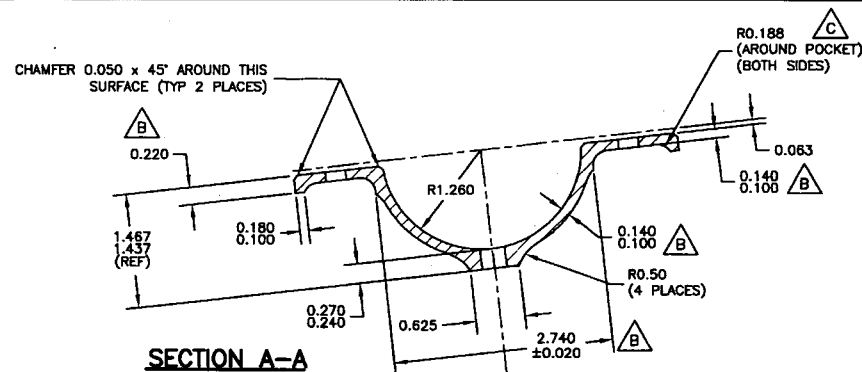
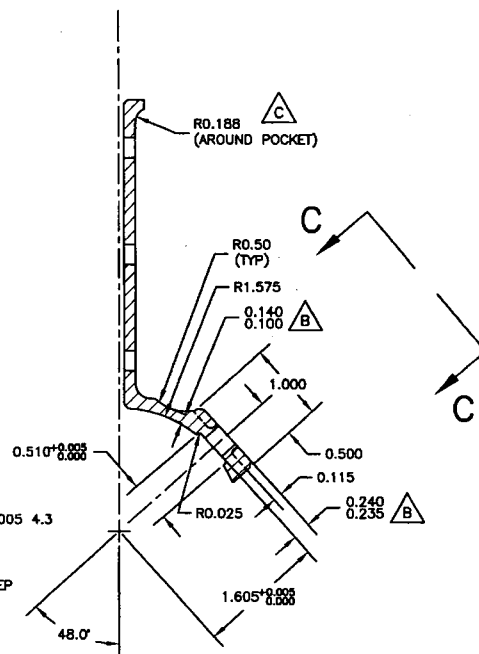
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

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DART DART AEROSPACE USA, INC.
 BELLEVUE, WA

DRAWING NO. D2939

SHEET 1 OF 1

SCALE

2:3

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 41928

01.02.12